

20-8069



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7822

Job Sheet 194353



Part No: 647.7822

Job Qty: 12 pcs

Part Name: Eye Bolt Fitting RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 6/12/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A IPP Rev A RQ 14.08.27 verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	12 pcs		6/12/19	0.00	0.02	Bandsaw - 1			SBL 19/05/20
110	HAAS 4 Axis - B4B	12 pcs		6/12/19	0.00	14.33	HAAS - 1 - B4B			
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			SBL 19/05/20
							HAAS - 4 - B4B			
120	QC 2	12 pcs		6/12/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
QC 2 - 50										
QC 2 - 51										
QC 2 - 52										
QC 2 - 57			SBL 19/05/20							
QC 2 - 62										
QC 2 - 63										
QC 2 - 8										
QC 2 - 66										
QC 2 - 64										
QC 2 - 65										
QC 2 - 5										
QC 2 - 71										
122	Conventional Mill - 1 - B4B	12 pcs		6/12/19	0.00	10.43	Conventional Mill - 1 - B4B			SBL 19/05/20
							Conventional Mill - 2 - B4B			

RT

SPACE

Part Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.ca

Doc: \$185297



822

4353

atch: \$185297

Date: 05/08/19

Plex 5/1/19 9:30 AM

Dart.Renwick.Jennifs

Plex 5/1/19 9:30 AM Dart, Renwick, Jennifer



Container No: S185297



Part: 647.7822

Job No: 194353

Serial No/Batch: S185297

Revision:

Inspector:

Exp Date:

Instructions:

Date: 05/30/19

5/1/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

124 QC 2	12 pcs	6/12/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130 QC 8	12 pcs	6/12/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-06-02
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Outsource - 4 - Anodize	12 pcs	6/12/19		ATG001-VC	10
					2019-06-03
150 Packaging 2-1 - Receive - B4B	12 pcs	6/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	

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					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 5	12	6/12/19	0.00	0.00	QC 5 - 10
		pcs				QC 5 - 12
						QC 5 - 17
						QC 5 - 18
						QC 5 - 19
						QC 5 - 22
						QC 5 - 24
						QC 5 - 3
						QC 5 - 43
						QC 5 - 49
						QC 5 - 51
						QC 5 - 58
						QC 5 - 68
						QC 5 - 9
						QC 5 - 50
						QC 5 - 30
						QC 5 - 40
180	Packaging 3-1 - Stock - B4B	12	6/12/19	0.00	0.00	Packaging 3 - 1 - B4B
		pcs				Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B

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				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	6/12/19	0.00 0.00	QC 21 - SA - 21	<i>JL</i>
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut Blanks at 3.188"

Descriptions: 110 - HAAS1-1 (HAAS CNC Vertical Machine) 1-Machine per folio F341 DWG REV: A FOLIO REV: AA

2- deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

122 - Conv Mill 1 (Manufacture as per dwg) Drill and c'bore as per dwg. Use DT10078.

124 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1,10.1) Issue P/O to ATG: 43624 1- Black Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required

150 - (Receive & Inspect for Damage & Mat'l Certs)

160 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location:) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	12 ft (1 ea)	100-Bandsaw - 1	<u>3x 5103 205</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.750X2.250	12	131	0

*MAT
used
3.231'*

*SCRAP
0.145'
+ 0.222'
0.367'*

TOTAL

mat used: 3.231 + 0.531 =

mat used: 3.231 + 0.531 = 3.762

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eye Bolt Fitting, RH	1.700Inches $\pm$ 0.005	1.705 1.695		1.703
2	Eye Bolt Fitting, RH	1.200Inches $\pm$ 0.005	1.205 1.195		1.203
3	Eye Bolt Fitting, RH	0.250Inches $\pm$ 0.005	0.255 0.245	Radius	0.250
4	Eye Bolt Fitting, RH	2.600Inches $\pm$ 0.005	2.605 2.595		2.599
5	Eye Bolt Fitting, RH	0.250Inches $\pm$ 0.005	0.255 0.245	Radius	0.250
6	Eye Bolt Fitting, RH	0.250Inches $\pm$ 0.005	0.255 0.245	Radius	0.25
7	Eye Bolt Fitting, RH	0.135Inches $\pm$ 0.005	0.140 0.130		0.135
8	Eye Bolt Fitting, RH	0.135Inches $\pm$ 0.005	0.140 0.130		0.137
9	Eye Bolt Fitting, RH	2.198Inches $\pm$ 0.005	2.203 2.193		2.199
10	Eye Bolt Fitting, RH	72.000Degrees $\pm$ 0.500	72.500 71.500	Angle	72°
11	Eye Bolt Fitting, RH	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	45°
12	Eye Bolt Fitting, RH	0.285Inches $\pm$ 0.005	0.290 0.280		0.285
13	Eye Bolt Fitting, RH	0.331Inches $\pm$ 0.005	0.336 0.326		0.331
14	Eye Bolt Fitting, RH	0.125Inches $\pm$ 0.005	0.130 0.120	Radius	0.125
15	Eye Bolt Fitting, RH	0.316Inches $\pm$ 0.006 - 0.001	0.322 0.315	Diameter	0.316
16	Eye Bolt Fitting, RH	0.495Inches $\pm$ 0.005	0.500 0.490		0.493
17	Eye Bolt Fitting, RH	0.610Inches $\pm$ 0.005	0.615 0.605	Diameter	0.614
18	Eye Bolt Fitting, RH	0.131Inches $\pm$ 0.005	0.136 0.126		0.131
19	Eye Bolt Fitting, RH	18.000Degrees $\pm$ 0.500	18.500 17.500	Angle	18.00
20	Eye Bolt Fitting, RH	0.745Inches $\pm$ 0.005	0.750 0.740		0.746

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Tel (613) 632-5200

PURCHASE ORDER

POHB043624



REVISED

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043624

PO Date: 6/3/19

Due Date: 6/25/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

E-MAILED
2019-07-08

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

RMA# 1251 (line 9)

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195680	647.7821	Eye Bolt Fitting LH Issue P/O to ATG : 1- Black Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG 648.7800 Rev. A	Received	-	6/25/19	29 pcs	29 pcs	0 pcs	\$9.63/pcs	\$0.00
2	194526	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	6/25/19	10 pcs	0 pcs	10 pcs	\$12.58/pcs	\$125.80



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PURCHASE ORDER

POHB043624



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	193347	RBE703A95-0505-00-1	Quill -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Received	-	6/25/19	36 pcs	36 pcs	0 pcs	\$3.08/pcs	\$0.00
4	193412	RBE350A94-3700-C-07	Top -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94- 3700-C-07 Rev 6 -Certificate of Conformity is required	Received	-	6/25/19	42 pcs	42 pcs	0 pcs	\$1.68/pcs	\$0.00
5	193409	RBE350A94-3700-C-05	Bottom -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94- 3700-C-05 Rev. 6 -Certificate of Conformity is required	Received	-	6/25/19	40 pcs	40 pcs	0 pcs	\$1.83/pcs	\$0.00



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PURCHASE ORDER

POHB043624



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	194353	647.7822	Eye Bolt Fitting RH (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: 1- Black Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Received	-	6/25/19	12 pcs	12 pcs	0 pcs	\$9.63/pcs	\$0.00
	195681	12	X JUL 24 2019	Partial	-	6/26/19	26 pcs	14 pcs	12 pcs	\$9.63/pcs	\$115.56
Sub Total:							38	26	12		\$115.56
7	193400	RBW109-3101-58-1-7	Handle (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: -ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant Certificate of Conformity is required	Received	-	6/25/19	16 pcs	16 pcs	0 pcs	\$4.33/pcs	\$0.00
	194724			Received	-	6/26/19	24 pcs	24 pcs	0 pcs	\$4.33/pcs	\$0.00
Sub Total:							40	40	0		\$0.00



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PURCHASE ORDER

POHB043624



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	195824	RBE703A94-1130-01-31	Tab Adjuster Gauge Plate - Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Received	-	6/25/19	4 pcs	4 pcs	0 pcs	\$3.53/pcs	\$0.00
	193103			Received	-	6/26/19	20 pcs	20 pcs	0 pcs	\$3.53/pcs	\$0.00
Sub Total:							24	24	0		\$0.00
9	194724-A	RBW109-3101-58-1-7	Handle - Issue P/O; - ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant - Material type: 6061T6 - Certificate of Conformity is required	Firmed	-	7/15/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
Line Item Note ***RE-WORK***											
Grand Total:										\$241.38	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918263

Date: 23-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
Quantity	Description
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.
✓ 12 ea	Part: 647.7822 ✓ Eye Bolt Fitting RH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25262 PO: POHB043624 ✓ Rev: A Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: JUL 23 2019 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	

Made in Canada.

RECEIVED
JUL 23 2019
DART AEROSPACE LTD.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 2R Date: Apr 13/2020Work Order update only ☐

Work Order: <u>194353</u> Part No. <u>647.7822</u> NCR No. <u>20-8069</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>19/5/2017</u>		Step #: <u>110</u>		QTY Effective: <u>12</u>			MRB (QSI042) Approval DAS <u>55</u> 9-89 MAR 24 2020		
Description Work Order Deviation				Disposition				Completed By SBL DAS <u>57</u> 9-89	
Part lifted ^{from vice} while machining. This resulted in the dimension being under tolerance. <u>1.200</u>				SCRAP and replace				Lead hand / Supervisor Approval Verification D. 19-05-29	
								QC / QA Coordinator Approval DAS <u>68</u> 9-89 MAY 29 2019	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ ☒ Manufacturing Process Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ ☒ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mis-labeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: _____									